

Work Order ID 62225

Wednesday, September 22, 2010 3:14:54 PM



Page 1

Item ID: D3660-1

Accept



Setup Start



Revision ID:

Stop



Item Name: CUFF

Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *10-9-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3660

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blank 7.300 " long

10.10.5

10

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per folio FA 708 & DWG D3660,
FOLIO REV: *10*
DWG REV: *13*
2-Deburr as required

10.10.5

10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10.10.5

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name:	CUFF				Stop	
Start Date:	9/22/2010	Start Qty:	10.00			
Required Date:	9/29/2010	Req'd Qty:	10.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				10	0		
	SA 10/10/06								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				10	0		
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

BR 10-10-7

10 0

10/14/12 10

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

Stop



Item Name: CUFF

Start Date: 9/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 477

0.00



Packaging

Memo

0.00

Packaging

10/10/12 (10)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12MF
10-10-12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 3:14:58 PM

Page 1

Work Order ID: 62225



Parent Item: D3660-1



Parent Item Name: CUFF

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6008-180		Manufactured	No			100	Each	8.0000	0.056	0.589474			
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Crosstube Extrusion

10.10.5

Location

Loc Qty

Loc Code

LG

8

46779

8

6.083

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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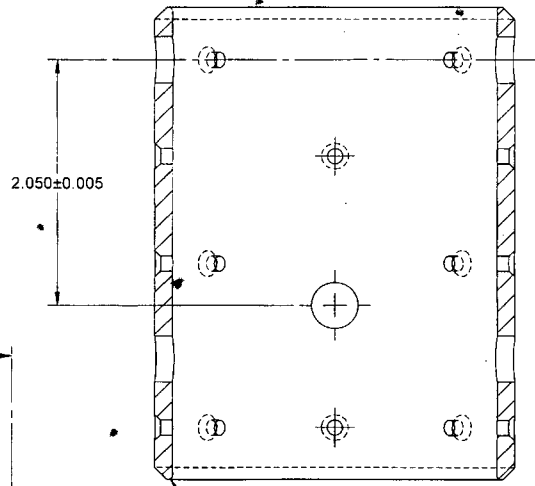
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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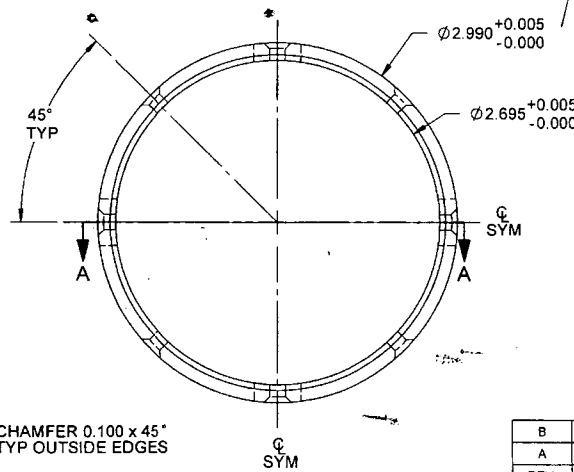
NOTE: Date & initial all entries

064
196



R0.032 TYP
INSIDE EDGES

SECTION A-A



D3660-1 CUFF

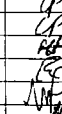
DRILL #30 (Ø0.128 REF)
C'SINK Ø0.230X100°
TYP 22 PLACES

Ø0.386 +0.005
-0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42225
PR 10-9-23

B	ADD Ø0.128 & Ø0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION		BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3660	REV. B SHEET 1 OF 1
		TITLE CUFF	SCALE NTS
DATE	08.03.03	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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